

Date: Wednesday, 1/25/2006 1:16:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 25611	
Estimate Number : 10267	
P.O. Number : N/A	Part Number : D2438
This Issue : 1/25/2006 S.O. No. : N/A	Drawing Number : D2438 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 25015	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 2/15/2006 Qty: 200 Um: Each
Checked & Approved By : JG 06.01.25	
Comment : Est: E 05.06.28 Bending removed KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 00000455

Laser cut as per Dwg D2438

Material release note is required

JP
06/01/27

2.0	D2438B	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)
 CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

06/2/16 200

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

06-02-17 Rev

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges

DL 06/02/25 (200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/21/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:16:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 25611

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5+178

06/2/27 200

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/27

Job Completion



06.02.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

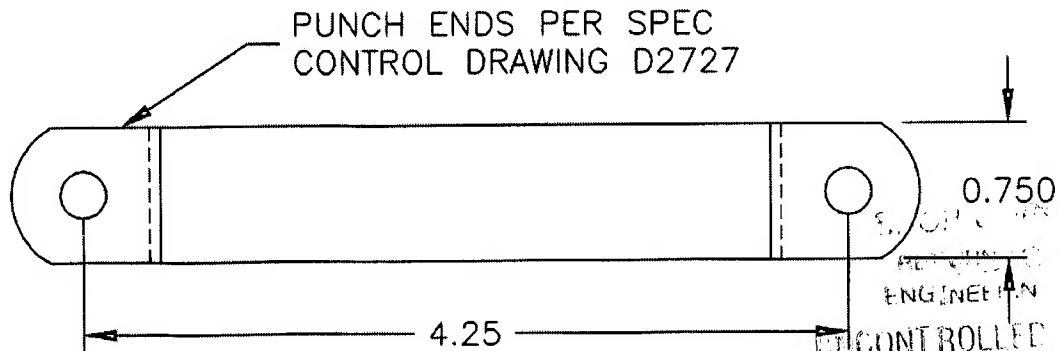
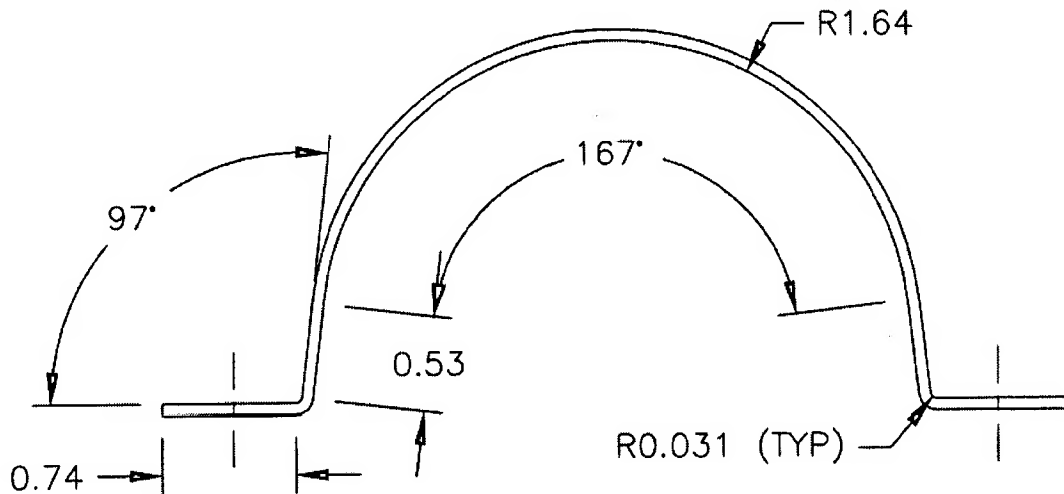
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

UNCONTROLLED
SUBJECT TO AV
WITHOUT NO
WORK ORDER
NO 25611

00.06.06
CP 00.06.07

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 5 OUR JOB NO J0138792 SHIPPING MEMO 0330870

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	<u>200 PCS</u>	<u>PO00000455</u>	<u>D2438</u>	<u>C</u>	<u>CLAMP</u>	<u>C</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>S.S.T 304</u>		<u>SAMUEL SPECIALTY/ AK STEEL</u>		<u>7341615 ATT'D</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 14 FEBRUARY 2006

G.F.I. Q.C. REP. Dalton H. St. J.



[Signature]
0602-17

LES MÉTAUX SPÉCIALISÉS SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: 1 AOÛT 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0066654
Customer's order #:

de commande SSMQ: 843000
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	10	.060" X 48" X 96"	304 2B		7341615

Bien à vous,
Yours truly,

José Raymond

Commis à l'administration.
Administration Clerk.





AK Steel Corporation
Metallurgical Test Report
Rockport Works
Rockport, IN 47635

Page 1

Load No. 7288793
SRN No. 7288793

CUSTOMER

SAMUEL & FILS & CIE LTEE (S)
PUR DEPT
2225 FRANCIS HUGHES DRIVE
LAVAL, CN H7S1N-5

SHIP TO

SAMUEL & FILS (QUEBEC) LTEE
2225 FRANCIS HUGHES
LAVAL, CN H7S1N-5

MILL ORDER NO.

252502-0523

PROCESSOR ORDER NO.

C97428-1

BUYERS ORDER NO.

C97428-1

PART NO.

COIL ID	HEAT	PARENT COIL ID	WEIGHT	ENGLISH UNITS	PRODUCT SIZE	METRIC UNITS
503431-05BA	7341615	0503431-05B	13,140 LBS. 5,960 KG.	.0590 NOM	48.0000 X COIL	
503431-05BB	7341615	0503431-05B	13,050 LBS. 5,919 KG.	.0590 NOM	48.0000 X COIL	
503431-05BC	7341615	0503431-05B	13,130 LBS. 5,956 KG.	.0590 NOM	48.0000 X COIL	

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7341615	.052	1.385	.032	.0011	.342	18.18	8.10	.35	.0390	.37						

SHIPPING DATE: 02/16/2005

REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL. MATERIAL FREE OF RADIOACTIVE ISOTOPES

PRODUCT DESCRIPTION

CR SHIT TYPE 304 STAINLESS #2B FINISH SLIT EDGE TEST REPORTS * ASTM A 240 -04 EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * ASTM A 480 -01 EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASTM E SA-240 SECTION II PART A (2001 ED, 2002 ADDENDA) EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * ASME SB-480 SECTION II PART A (2001 ED) EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASTM A 262 -01 PRACTICE E * ASTM A 666 -00 EX 6.1.9 ELONG WILL BE DETERMINED BY ASTM E 8, EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION IN ALL CASES

PARENT COIL ID	POS (E/T)	DIR (L, T, D)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. .2% OFFSET (KSI)	ROCKWELL HARDNESS Fall	ROCKWELL HARDNESS Front			
0503431-05B	T	T	A.S.T.M	58.2	94.7	47.1	B 85.3	B 85.8			

*** CONTINUED ON NEXT PAGE ***

22
04/05/05

22 COPIES
TEST
03/30

PAGES:001 R=92%

ID: SAMUEL ET FILS

FOX: AK Steel RightFax

FEU-17-2005 06:45



AK Steel Corporation
Metallurgical Test Report
Rockport Works
Rockport, IN 47635

Page 2

Load No. 7288793

SRN No. 7288793

CUSTOMER

SAMUEL & FILS & CIE LTEE (S)
POR DEPT
2225 FRANCIS HUGHES DRIVE
LAVAL, CN H7S1N-5

SHIP TO

SAMUEL & FILS (QUEBEC) LTEE
2225 FRANCIS HUGHES
LAVAL, CN H7S1N-5

MILL ORDER NO.

252502-0523

PROCESSOR ORDER NO.

C97428-1

BUYERS ORDER NO.

C97428-1

PART NO.

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	BEND 180 IT						
6583431-05B	T		A.S.T.M	PASS	OK						

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT
AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

MWQP0009 3/99

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK
Steel Corporation. TO AVOID THE POSSIBILITY OF DELAY OR MISUSE OF THIS REPORT TO A
THIRD PARTY IT MUST BE SIGNED BY AND UNDER THE NAME OF SUCH CONSIGNEE"

SIGNED

[Signature]
QUANTITY MANAGER

DATE 02/17/2005 TIME 08:23 AM

PAGES: 002 R=92%

ID: SAMUEL ET FILS

FAX: AK Steel RightFax

FEU-17-2005 06:45